

Work Order ID 59008

Friday, May 21, 2010 10:49:11 AM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 5/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 1Date: 10-5-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 111679

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

②

G100603

SAP 10-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59008

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Page 2

Item ID: D3852-041 Accept Setup Start Stop
Revision ID:
Item Name: Rib Assembly
Start Date: 5/21/2010 Start Qty: 2.00 Cust Item ID:
Required Date: 5/24/2010 Req'd Qty: 2.00 Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
 QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(2)	10.06.04		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Swloglog		(2) -041			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAD	10-06-04	(2)			

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 5/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07

ME

10-6-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, May 21, 2010 10:49:15 AM

Page 1

Work Order ID: 59008

Parent Item: D3852-041

Parent Item Name: Rib Assembly

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Start Date: 5/21/2010

Required Date: 5/24/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3

Manufactured

No

100

Each

8.6739

0.18

0.378947



Basket Hoop



SAD 10-05-27

Location

Loc Qty

Loc Code

WA

8.673921053

55697

2.1053E-05

56426

2.6739

57504

6

0.3790

D3759-1

Manufactured

No

100

Each

36.0000

1

2



Bushing



S

10-06-03

Location

Loc Qty

Loc Code

WA

36

54072

9

58159

1

58256

26

358581

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

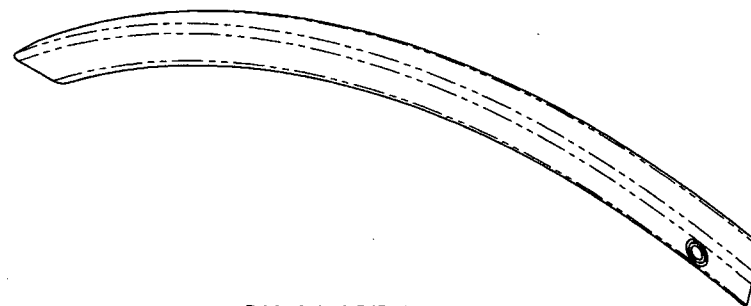
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59008

PS10-5-21

RELEASE
08/11/07 MP

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs EACH
8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3852	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		RIB ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.07		

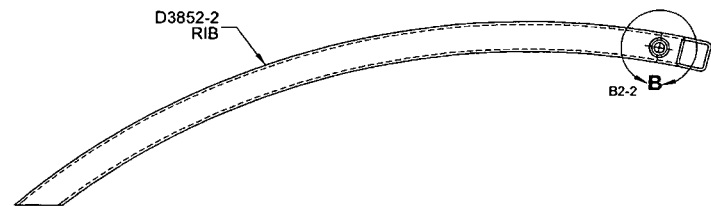
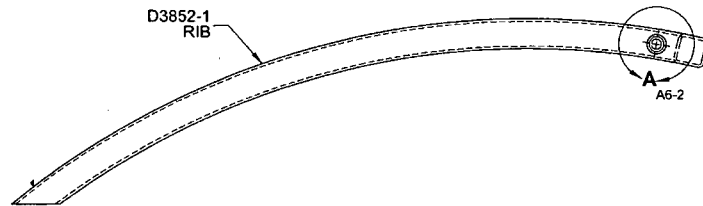
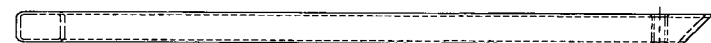
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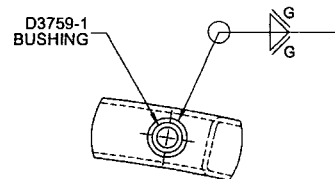
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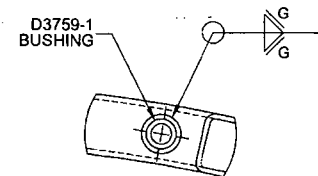


D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2



DETAIL B
SCALE 2X C2-2

w/o 59008

RELEASED
08/11/15

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>125</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>125</i>	D3852	SHEET 2 OF 3
APPROVED	<i>125</i>	TITLE	SCALE
DE APPR.	<i>125</i>	RIB ASSEMBLY	NTS
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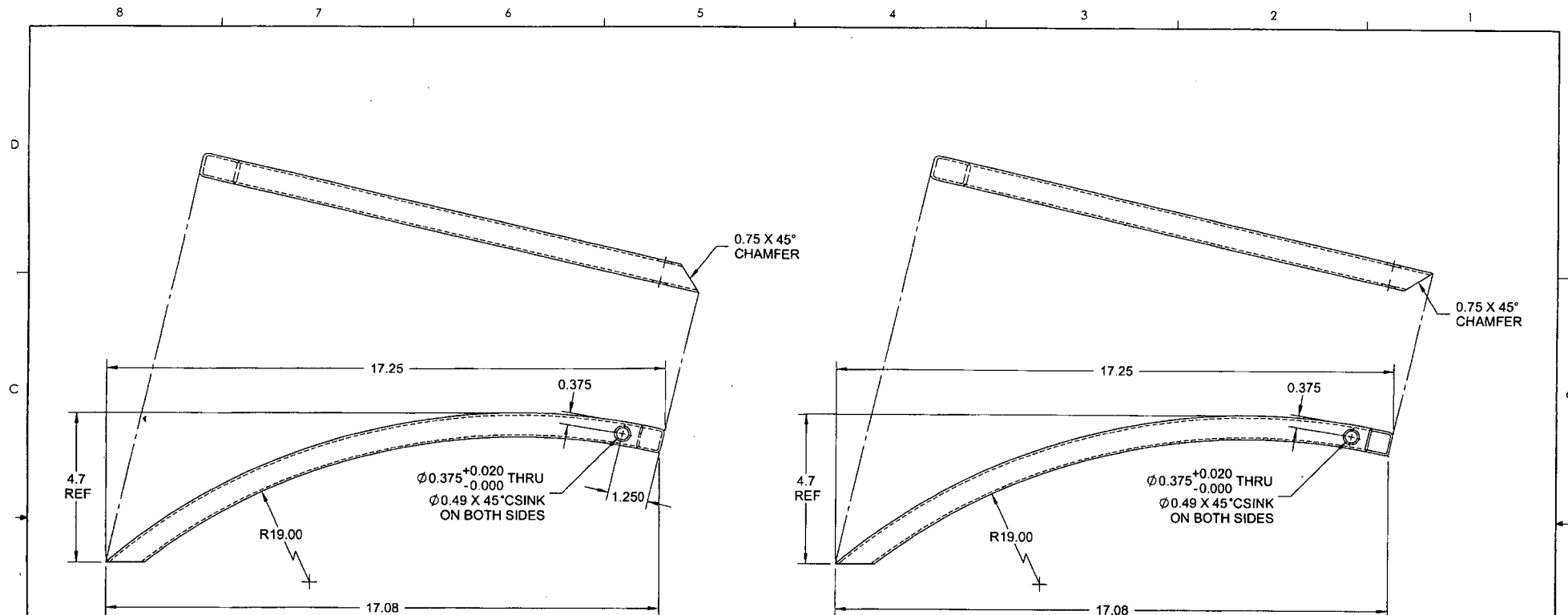
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D3852-1 RIB

D3852-2 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

wlb 59008

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3852 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE RIB ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.11.07	

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